

Work Order ID 64361

Thursday, December 02, 2010 1:31:56 PM



Page 1

Item ID: D3570-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/2/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-12-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

0.00

I-Cut as per Dwg D3570

Dwg Rev: FProg Rev: F

GRAIN DIRECTION AS PER DWG

2-Deburr if necessary



110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

Memo

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

17.

BL-10-12-7

160



Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

M 11/25/09

Memo

0.00

START TIME:

8:00

OVEN TEMPERATURE:

300°

FINISH TIME:

5:30

17.

BL-10-12-9

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11/10/12/09

17

P

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Page 4

Item ID: D3570-3

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Item Name: Bracket

Stop



Start Date: 12/2/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: G ASet Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

Memo

0.00

SD 10/12/10

(17)

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/14 JJ

10/12/10
(17)

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NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 1:32:00 PM

Page 1

Work Order ID: 64361



Parent Item: D3570-3



Parent Item Name: Bracket

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 15.00

Required Qty: 15.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	72.0600	0.087	1.373684			
6061-T6 .125 Sheet												R10-12-6	

Location	Loc Qty	Loc Code
MAT21	72.06	
113608	72.06	113608

(17)

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DART AEROSPACE LTD	Work Order:	G413G1
Description: Bracket	Part Number:	D3570-3
Inspection Dwg: D3570	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BR</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-12-06	Date:	10/12/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.09	New Issue	KJ	M

W/O:		WORK ORDER CHANGES					
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SHOP COPY

RETURN TO 4

ENGINEERING

UNCONTROLLED COPY

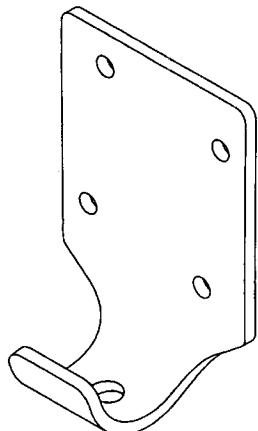
SUBJECT TO AMENDMENT

WITHOUT NOTICE

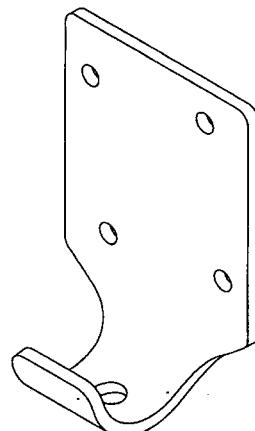
WORK ORDER

NO. 141361

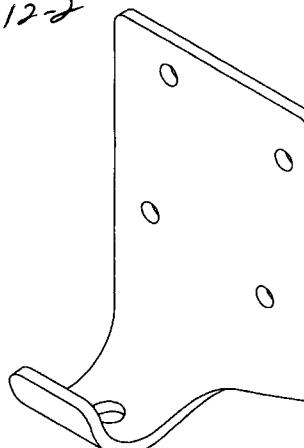
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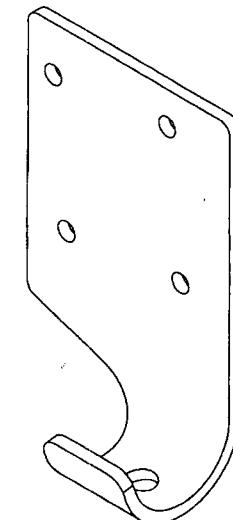
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

RELEASED
09/04/12 M

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.		AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.		AJS	09.04.01
C	UPDATE DIMS FOR CLARITY		LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50		LE	07.04.16
A	NEW ISSUE		LE	07.02.07
REV.	DESCRIPTION		BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	DRAWING NO.	REV. E	
CHECKED	<i>[Signature]</i>	D3570		
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE	
APPROVED	<i>[Signature]</i>	BRACKET	NTS	
DE APPR.	<i>[Signature]</i>	DATE	09.04.22	
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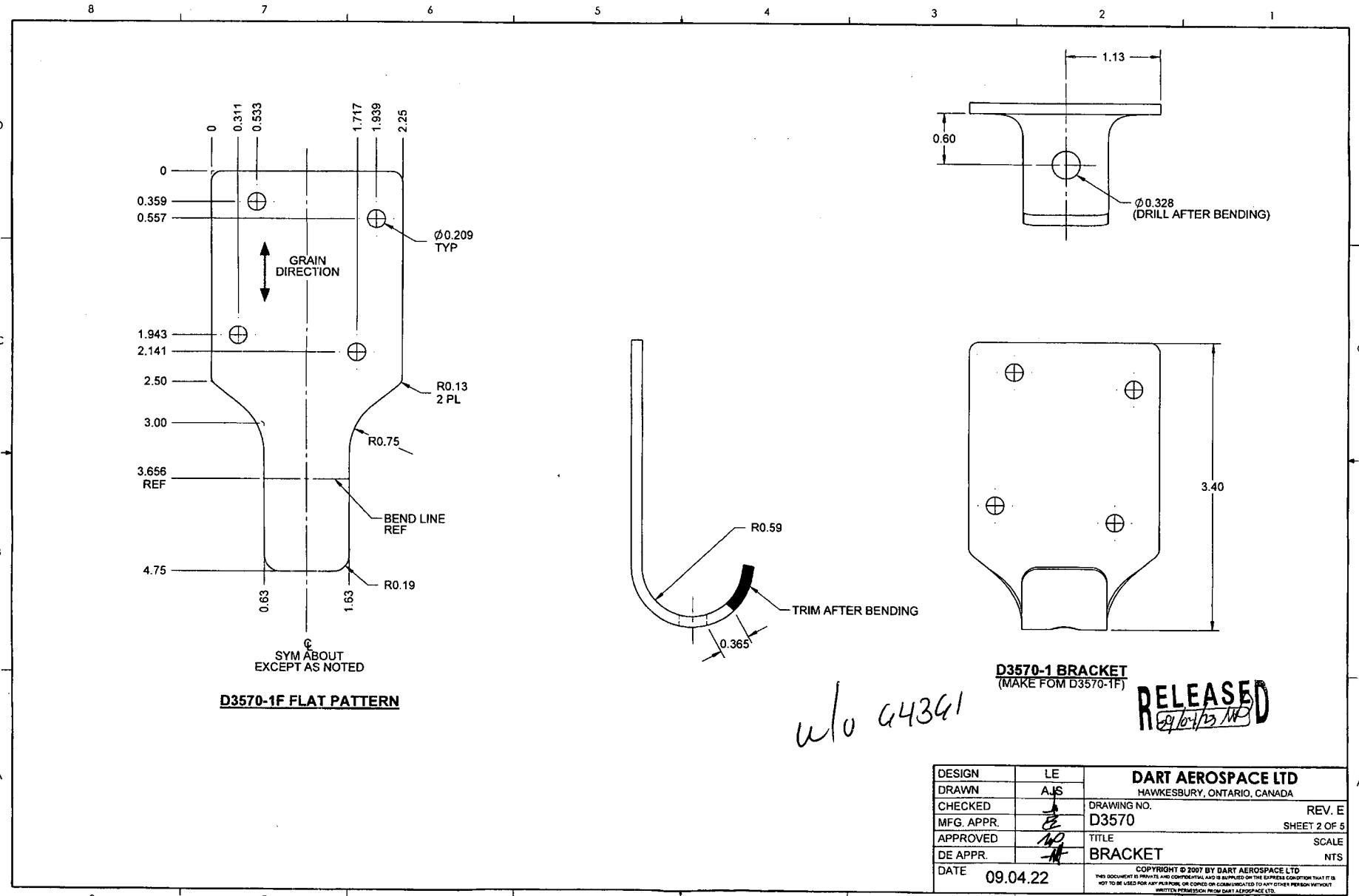
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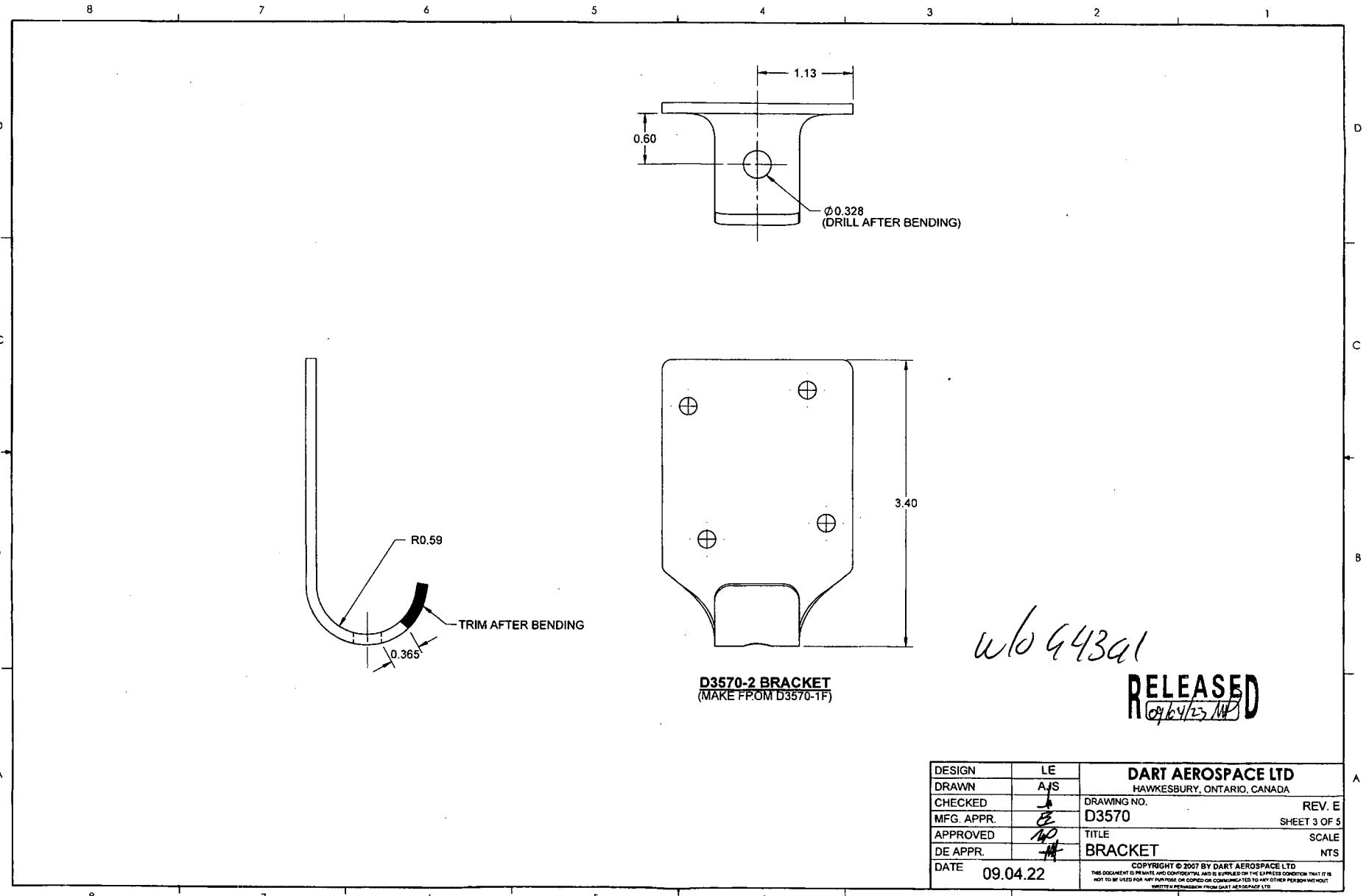
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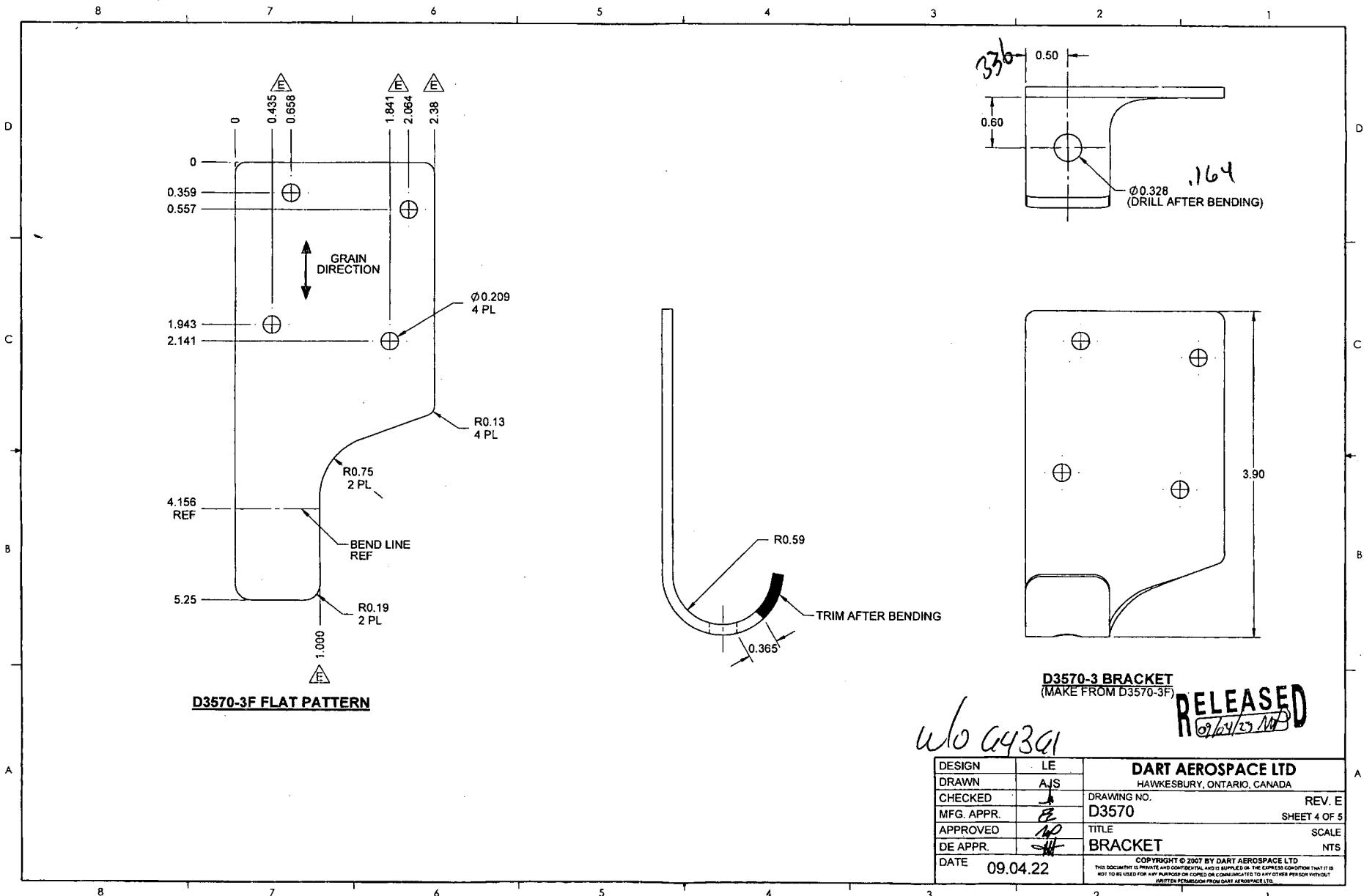
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**D3570-3 BRACKET
(MAKE FROM D3570-3F)**

RELEASED
09/04/23 MB

DESIGN	LE	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. E	
MFG. APPR.	<i>PE</i>	D3570	SHEET 4 OF 5	
APPROVED	<i>WJ</i>	TITLE	SCALE	
DE APPR.	<i>SH</i>	BRACKET	NTS	
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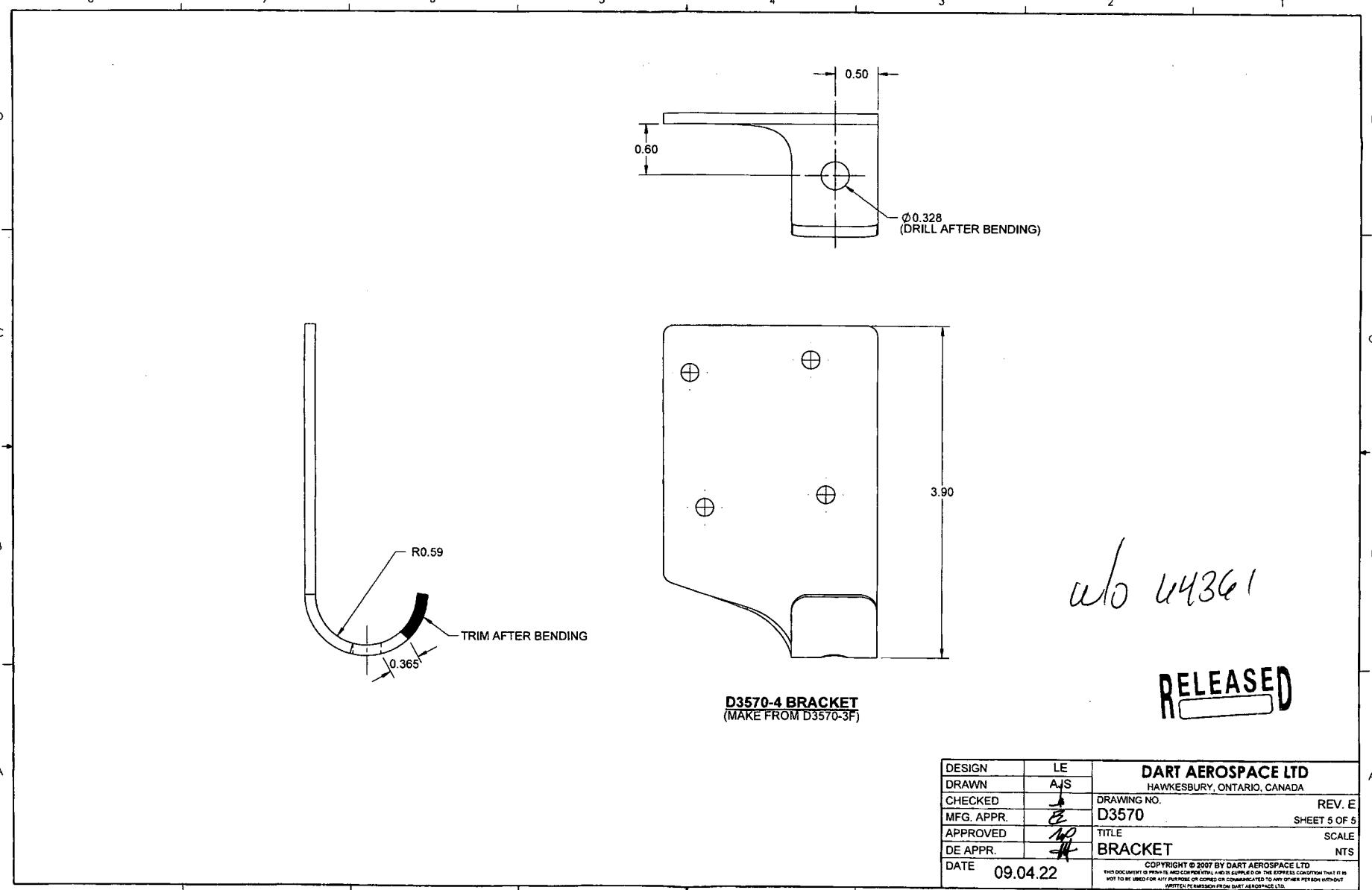
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DESIGN	LE	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	[initial]	DRAWING NO.
MFG. APPR.	[initial]	D3570
APPROVED	[initial]	REV. E
DE APPR.	[initial]	SHEET 5 OF 5
DATE	09.04.22	SCALE NTS

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